

Date: Thursday, 01/05/2008 10:24:51 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT  
Job Number : 38934  
Estimate Number : 12437  
P.O. Number :  
This Issue : 01/05/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D35181  
First Issue : / / Type : MACHINED PARTS Drawing Number : D3518 REV.B  
Previous Run : 31683 Project Number : N/A  
Material :  
Due Date : 06/05/2008 Qty: 4 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 06-11-20 JLM  
est rev B rev B dwg 07.04.09 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6H0875 6061-T6 7/8" HexBar



Comment: Qty.: 1.1550 f(s)/Unit Total: 4.6200 f(s)  
6061-T6 7/8" HexBar  
Batch: M104182

(4)

MMF 08/05/1

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE  
Turn as per Dwg D3518,

(4)

1-Face to Length and Drill & Tap.

MMF 08/05/1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/05/1

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
Drill as per Dwg D3518.

(4)

1-Drill 2x .191" holes & 1x .0625" hole

MMF 08/05/01

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/05/01

(4)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 10:24:51 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 38934

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*08-05-02 (4)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*BR 08-05-05 (4)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\*Mask threads with AN6 bolt\*\*\*\*\*

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *8:05AM*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *8:35AM*

*AD 08-05-05 (X4)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BR 08-05-05 (4)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*80 08/05/05 (4)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/06 (4)*

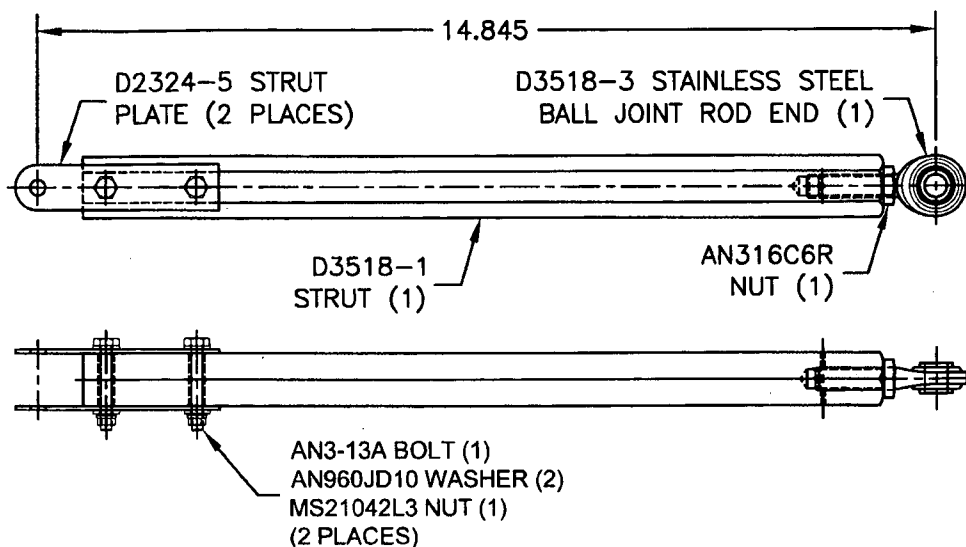
Job Completion



*YMF 08-05-05*



|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>PH</i>  | DRAWN BY<br><i>PH</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>PH</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 1 OF 3 |
| DATE<br>06.10.23     |                       | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:3           |
| A                    | 06.06.21              | NEW ISSUE   |                        |
| B                    | 06.10.23              | RE-DESIGN   |                        |



### D3518-041 STRUT ASSEMBLY

| QTY<br>-041 | Part Number | Description                        |
|-------------|-------------|------------------------------------|
| X           | D3518-041   | STRUT ASSEMBLY                     |
| 2           | D2324-5     | STRUT PLATE                        |
| 1           | D3518-1     | STRUT                              |
| 1           | D3518-3     | STAINLESS STEEL BALL JOINT ROD END |
| 2           | AN3-13A     | BOLT                               |
| 1           | AN316C6R    | NUT                                |
| 4           | AN960JD10   | WASHER                             |
| 2           | MS21042L3   | NUT                                |

W/O 38934

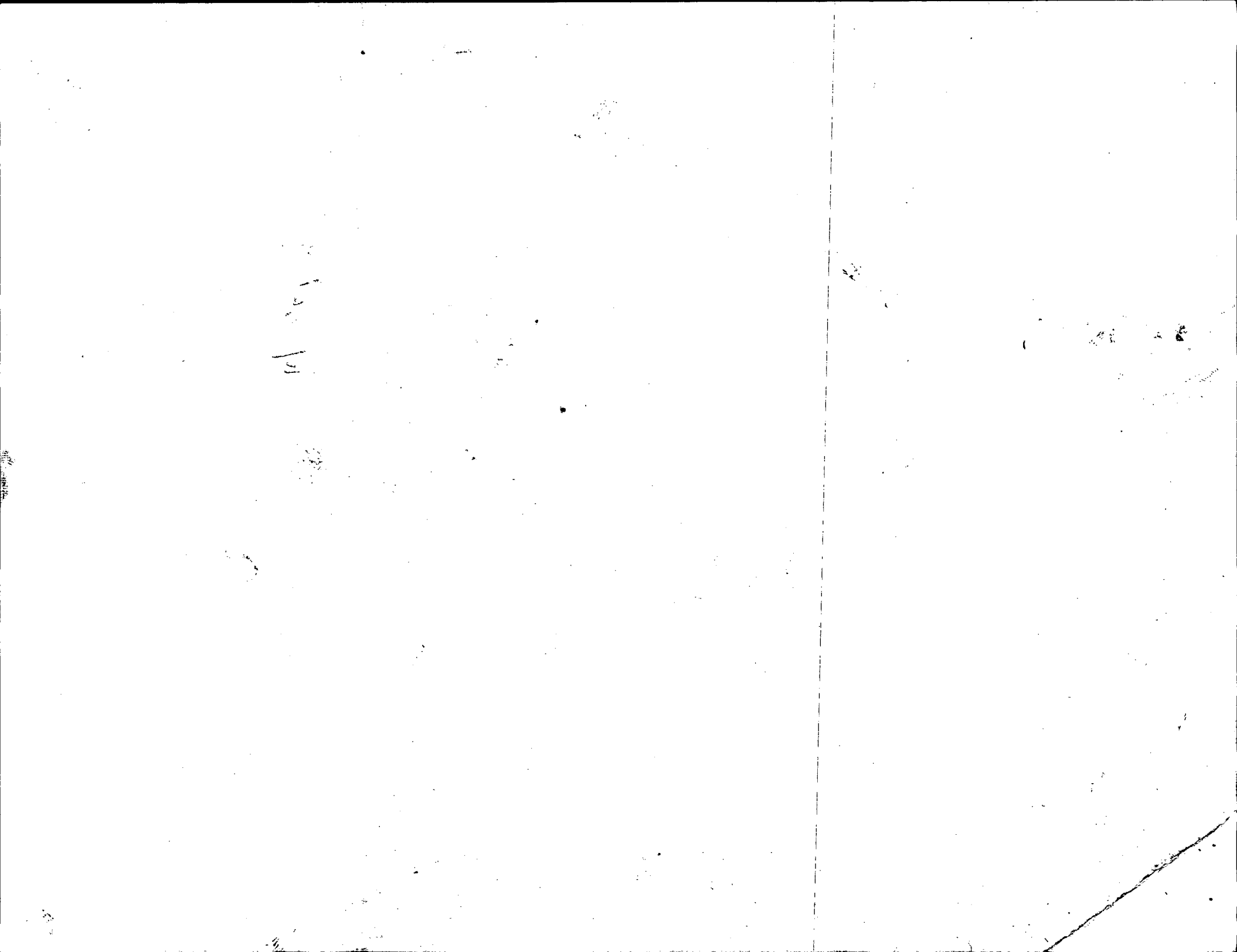
#### NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

RELEASED  
06.11.17 *PH*

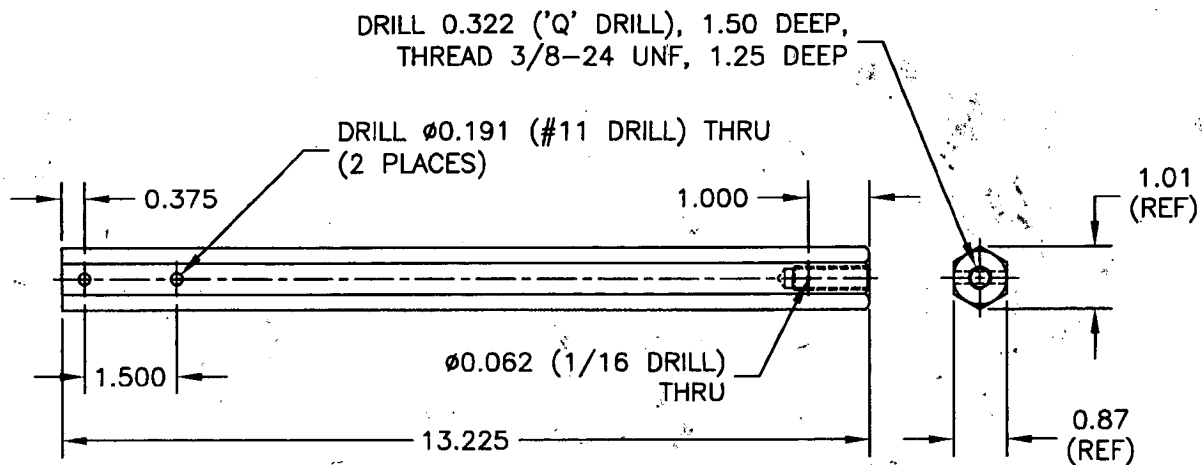
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**DART**

|                  |               |   |                        |
|------------------|---------------|---|------------------------|
| DESIGN<br>B      | DRAWN BY<br>B | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>PH    | APPROVED<br>H | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 2 OF 3 |
| DATE<br>06.10.23 |               | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:3           |

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED

06.11.17

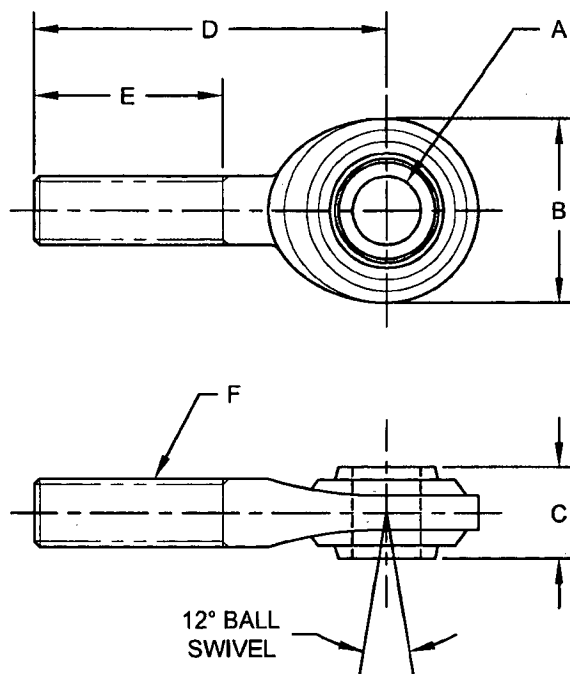
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|                              |                                |  |                        |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i> | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>         | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                                     | REV. B<br>SHEET 3 OF 3 |
| DATE<br>06.10.23             |                                | TITLE<br>BASKET (A119) STRUT                             | SCALE<br>1:1           |

## SPECIFICATION CONTROL DRAWING



| DART P/N | A     | B    | C    | D     | E    | F                 | LOAD* | POSSIBLE SUPPLIER             |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3  | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24<br>UNF, RH | 4012  | McMASTER-CARR,<br>P/N 2458K14 |
|          |       |      |      |       |      |                   |       |                               |

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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